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D5549-3

Job Sheet 186831



Part No: D5549-3

Job Qty: 2 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5549 REV.B SHEETS 7, 8 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	12/7/18	12/7/18	0.00	4.13	Waterjet - Flow		12/18/18/30
110	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Waterjet-4		04/18/12/30
120	CNC Vertical Machining	2 pcs	12/7/18	12/7/18	0.00	8.66	HAAS1-4		11/19/11/14
130	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Machining-4		12/19/01/15
140	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC8 Machining-4		D.B. 19/01/15
150	HandFinish	2 pcs	12/7/18	12/7/18	0.00	1.14	HandFinish1		DEB 19-01-15
160	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC7-5		DEB 19-01-15
170	Powdercoat	2 pcs	12/7/18	12/7/18	0.00	0.22	Powdercoat1		DEB 19-01-15
180	QC	2 pcs	12/7/18	12/7/18	0.00	0.00	QC3		JAN 16 2019 68
190	Packaging	2 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	STUNA	JAN 14 2019 9-89
200	QC21-SA	2 Ea	12/7/18	12/7/18	0.00	0.00	QC21		JAN 16 2019 21

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 120 - Drill holes as per dwg manually on Hass4 Dwg rev: B

1138997 170 - ***Mask holes or blow out access powdercoat in holes*** START TIME: 1:10 OVEN TEMPERATURE:
320° FINISH TIME: 1:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X8.000	6061T6 Bar 1.000 X 8.000	9.1600 ft (4.58 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X8.000	9	6	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	186831
Description:		Part Number:	D5549-3
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	$\pm .000 + .030$	.503	1			
.65	$\pm .000 + .030$	.652	1			
7.23	$\pm .030$	7.23	1			
10.73	$\pm .030$	10.73	1			
11.23	$\pm .030$	11.23	1			
15.23	$\pm .030$	15.23	1			
19.23	$\pm .030$	19.23	1			
23.23	$\pm .030$	23.23	1			
27.23	$\pm .030$	27.23	1			
31.23	$\pm .030$	31.23	1			
35.23	$\pm .030$	35.23	1			
39.23	$\pm .030$	39.23	1			
43.23	$\pm .030$	43.23	1			
46.73	$\pm .030$	46.73	1			
3.50	$\pm .030$	3.490	1			
1.25	$\pm .030$	1.258	1			
1.06	$\pm .030$	1.056	1			
6.50	$\pm .030$	6.511	1			
1.00	$\pm .010$	1.034	1			
3.36	± 0.030	3.360	1		Visual SVCS	
2.250 (2x)	± 0.010	2.250	1		"	
4.500 (2x)	"	4.500	1		"	
1.30 (4x)	± 0.030	1.300	1		"	
1.500 (2x)	± 0.010	1.500	1		"	
2.300	"	2.305	1		"	
0.600	"	0.605	1		"	
0.760	"	0.760	1		"	
1.800	"	1.800	1		"	
3.600	"	3.600	1		"	

Measured by:	de	Checked by:	amf	QC Inspector:	
Date:	18/12/30	Date:	19/01/15	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	
0.377 (6x)		$\pm 0.006 - 0.001$	0.378	✓
0.377 (2x)		$+0.002 - 0$	0.378	✓
0.257 (10x)		$+0.005 - 0.001$	0.257	✓

Visual SVCS
Gage Pins
Visual SVCS



Container No: S140899



Part: D5549-3

Job No: 186831

Serial No/Batch: S140899

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 12/30/18